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**D4635-142**  
**Job Sheet 167085**



Part No: D4635-142

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |                |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time      |
| 90    | Start up Operation | 1 Ea  |            | 11/9/17  | 0.00      | 0.00    | Start Up Small Fab    | D.M.L 17-12-12 |
| 100   | Small Fab          | 1 pcs |            | 11/9/17  | 0.00      | 0.80    | Small Fab             | D.M.L 17-12-12 |
| 110   | Small Fab          | 1 pcs |            | 11/10/17 | 0.00      | 0.80    | Small Fab             | D.M.L 17-12-12 |
| 120   | QC                 | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | QC5                   | PS 17-12-13    |
| 130   | Packaging          | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | Packaging3            | D.H.L 17-12-14 |
| 140   | QC21-SA            | 1 Ea  |            | 11/10/17 | 0.00      | 0.00    | QC21                  | DEC 14 2017    |

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 137285 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: TH

140 - QC21- Final Inspection - Work Order Release

### Job Allocations

| Operation             | Component Part        | Required | Inventory | Allocated | Std Qty |
|-----------------------|-----------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D4635-2 - 164283      | 1        | 2         | 0         | 0       |
|                       | D4669-1 154904        | 2        | 27        | 0         | 0       |
|                       | D4695-042 - 156359    | 1        | 1         | 0         | 0       |
|                       | 05✓ D4732-3 - 123201  | 1        | 4         | 0         | 0       |
|                       | 05✓ D4732-31 - 123215 | 1        | 4         | 0         | 0       |
|                       | 05✓ D4732-35 - 123217 | 1        | 5         | 0         | 0       |
|                       | 05✓ D4732-7 - 123203  | 1        | 2         | 0         | 0       |
|                       | D5022-1 - 126184      | 1        | 4         | 0         | 0       |

### Part Specifications

Specifications could not be found.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: \_\_\_\_\_

### DISPOSITION

Rework ☐  
Scrap ☐  
Use-as-is ☐  
approved ☐

Skid-tube ☐  
Machining ☐  
Thermoforming ☐  
Large Fab ☐

Cross tube ☐  
Small Fab ☐  
Finishing ☐  
Composite ☐

Water Jet ☐  
Prod. Eng. Coord. ☐  
Rec/Store/Packaging ☐  
Supplier ☐

Engineering ☐  
Quality ☐  
Other ☐

QTY Effective : \_\_\_\_\_

MRB (QSI042) Approval

### Disposition

Completed By

Lead hand / Supervisor  
Approval Verification

QC / QA Coordinator  
Approval

### FAULT CATEGORY

ntic ☐ Temperature/Cure  
Set-up ☐  
BOM/Route ☐  
Broken/Damage/Defect ☐  
Inspection Incomplete/Unqualified ☐  
Contamination ☐  
Countersink ☐  
Cut Too Short ☐  
Instructions Incomplete/Unclear ☐  
Drill Holes ☐

Power Loss/Surge ☐  
Folio/Program ☐  
Grain ☐  
Weld ☐  
Wrong Stock Pulled ☐  
Out of Sequence ☐  
Off-set ☐  
Misabeled ☐  
Fit/Function ☐  
Misaligned/off center ☐

Positioned Wrong ☐  
Outside Dimensions ☐  
Over/Under tolerance ☐  
Part Incorrect ☐  
Part Lost/Missing ☐  
Part Moved ☐  
Drawing ☐  
Finish ☐  
Misread ☐  
Turning Sequence ☐

Past Expiry Date ☐  
Misidentified ☐

Manufacturing Process ☐  
Past Due ☐

OTHER : \_\_\_\_\_

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**D4635-142**

**Start up Operation**

Mfg Date: 12/07/17

Job No: 167085

**PART NO:**

**Revision:**

**Operation:**

**Change No:**